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<p>84-050928/09 F09 JAME-18.08.82 JAMES RIVER-DIXIE *EP -101-319-A 18.08.82-US-409055 (22.02.84) D21f-11 D21h-05/14 Bulked fibrous web prodn. - by mechanically kinking dry paper making fibres and wet-forming web before kinks disappear</p>	<p>F(5-A2B, 5-A3) 049</p>
<p>C84-021352 D/S: AT BE CH DE FR GB IT LI NL SE</p> <p>Hydrophilic papermaking fibres, pref. of cellulose ester material having less than 1.0 degree of substitution of hydroxyl gps., are subjected to mechanical deformation to twist, kink and curl them without breakage or fibrillation, specifically by dry hammermilling or wet refining. The deformations are retained for only a short time when wet with water, so the fibres are formed into aq. dispersion and formed into a dewatered web before the deformations disappear.</p> <p><u>ADVANTAGE</u> Paper of high bulk, softness and absorbency is made without additional creping steps.</p> <p><u>PREFERRED</u> Pref. the dispersion is formed with aq. medium foamed by adding a surfactant, and fibres in the dispersion include</p>	<p>at least 10% deformed fibres, the remainder being conventional papermaking fibres such as natural cellulosic fibres. Pref. the dispersion contains 0.3-1.2 wt % fibres. (40pp006RBHDwgNo0/0). (E) ISR: No Search Report</p> <p>EP-101319-A</p>

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(54) Fibrous webs of enhanced bulk and method of manufacturing same.

(57) Fibrous webs of improved bulk and softness are produced by subjecting hydrophilic papermaking fibers to mechanical deformation, e.g. hammermilling, sufficient to deform the fibers without substantial fiber breakage producing treated fibers dispersing the resulting curled or kinked treated fibers, preferably in admixture with conventional papermaking fibers, in an aqueous medium to form a fiber furnish with minimal agitation, and forming a wet laid web from the resulting fiber furnish within a period of time, e.g. within 5 minutes, such that the deformations of the treated fibers are at least partially retained and impart enhanced bulk and softness to the finished fibrous web.

EP 0 101 319 A2

Fibrous Webs of Enhanced Bulk and
Method of Manufacturing Same

5 This invention relates to a process for the production of
fibrous web products of enhanced bulk and superior forma-
tion and to a process for making such fibrous web products.
In one of its more specific aspects, this invention relates
to a method for the production of improved fibrous web
10 products comprising from about 25 to about 75% by weight
treated natural cellulose fibers which have been mechan-
ically deformed, and from about 75 to about 25% by weight
untreated conventional cellulosic pulped fibers. In the
present invention, conventional hydrophilic fibers suit-
able for the making of paper are treated mechanically to
15 impart short-lived deformations in the fibers which are
then mixed with conventional cellulosic papermaking fibers
in an aqueous dispersion and the resulting dispersion of
mixed fibers dispensed onto a moving foraminous forming
means to form a wet web. The wet web is then processed
20 conventionally to a product web having enhanced bulk as a
consequence of the presence of treated fibers incorporated
in the product.

25 In the manufacture of fibrous webs, for example, paper web
products, such as paperboard and tissue products, conven-
tional processing techniques dispense a dilute furnish
consisting of an aqueous slurry of hydrophilic fibers,
e.g., cellulosic fibers, onto a moving foraminous wire
support means. Water drains through the support means,
30 often aided by application of a vacuum forming a wet web of
fibers on the wire. The wet web is dried subsequently, and,
if desired, the web leaving the drier can be creped to
achieve additional bulk and softness. In the process
disclosed in U.S. Patent 3,716,449 to Gatward et al,
35 incorporated herein by reference, the papermaking fibers

are uniformly dispersed in a foamed liquid comprising an aqueous solution of a foamable water-surfactant and the foamed liquid containing the fibers is dispensed onto a moving foraminous support means.

5

In both processes, the wet web, prior to the thermal drying step, is often wet pressed by means of consolidation rollers to remove a portion of the residual water from the wet web thereby reducing drier load. As a consequence of
10 wet pressing, a web of greater strength and density may be made, but the bulk of the product web is reduced. High bulk is desirable in many paper products to achieve high liquid holding capacity, and relatively low fiber content per ream of web product.

15

It is known that kinked, bent, curled and otherwise distorted hydrophilic fibers, for example, natural cellulose fibers, can be obtained by various known chemical and mechanical treatment methods and that such fibers are
20 useful to enhance the bulk of fibrous webs.

Present practice in the manufacture of webs having enhanced bulk and softness is to treat the bulk enhancing fibers mechanically or chemically under conditions which produce
25 essentially permanently kinked or curled treated fibers. It is also known that conventional wet milling of paper-making fibers produces treated fibers containing kinks and curls of transient duration in an aqueous environment. The energy required for wet milling is generally not of the type
30 and of the severity necessary to permanently kink the fibers.

The present invention relates to a process for the manufacture of fibrous webs of enhanced bulk in which treated
35 hydrophilic fibers, characterized by kinks, curls, bends,

twists or like deformations are dispersed in an aqueous medium, preferably a foamed liquid, which minimizes water absorption and subsequent reversion of the treated fibers to their original form. The dispersion is immediately dispensed onto a moving foraminous support means to form a fibrous web preferably in a period of time within the range of 0.5 to 5 minutes. At least 10 percent by weight treated fibers are incorporated into the web to form a product having high bulk, high porosity, and a high absorbency. The process results in a product processing greater bulk, softness and absorbency than conventional wet laid web products although with some sacrifice of tensile strength.

In carrying out the process as it may be applied to cellulosic paper web products, two distinct types of fibers are employed, although the source of the fibers may be identical. The preferred first type of fiber is conventional bale pulp papermaking fibers as may be produced by the sulfite, sulfate or other processes. Characteristically, the conventional fibers are hydrophilic and essentially linear, with a fiber length between about 1.0 to 6.0 mm. The second type of fibers (treated fibers) are also hydrophilic, and are preferably cellulosic fibers characterized by kinks, curls, twists or other deformations. Although the length of the preferred treated cellulosic fibers in a relaxed state may also be about 1.0 to 6.0 mm, their overall length in the deformed state is considerably reduced. The treated fibers can be obtained mechanically by wet or dry milling, preferably by defiberizing laps or bales of conventional otherwise untreated hydrophilic fibers in a hammermill or an equivalent device.

In the process of this invention for making paper webs, conventional cellulosic pulp is treated in a pulper for

less than about one hour at a consistency of between 2 to 6 weight percent water and then transferred to a machine chest for storage for up to about six hours or more. The consistency of the slush pulp is subsequently increased to
5 between about 8 to about 55% by weight in a stock press, and then transferred to a mix tank into which treated dry hydrophilic fibers, preferably natural cellulose fibers, are also added, along with sufficient aqueous diluent to achieve a consistency of between about 0.3 to about 4% fiber
10 by weight. The forming medium may be water but preferably is a foamed dispersion comprising air, water and surfactant.

15 In a preferred continuous process embodiment of this invention, steady state operation is achieved such that there is a closed loop system containing an aqueous foam. Parameters of the mixing step are treated fiber residence time, nature and severity of agitation, and process temperature. These parameters are combined such that during the time
20 interval between incorporation of the treated dry fibers into the aqueous foam in the mix tank and discharge of the final dilute foamed dispersion through the forming header onto the forming wire, the treated hydrophilic fibers retain at least a part of the deformation induced in them.
25 Treated fiber residence time in the mix tank should generally be no greater than 10 minutes, preferably no greater than 5 minutes, under mixing conditions adapted to minimize relaxation of the kinks and curls. If necessary, the uniform dispersion leaving the mix tank is further diluted
30 with foamed liquid from the silo to achieve a consistency of between 0.3 to 1.2% fiber by weight, transferred to a forming header, and dispersed onto a moving foraminous support means to form a wet web, a major portion of the foamed liquid passing through said support means for re-
35 cycling. The wet laid web then follows a conventional path

through the remainder of the web manufacturing process.

The products thus produced by this process have greater bulk than products made in like manner with only conventional papermaking fibers, and show significantly superior formation.

The process of this invention will be more readily understood with reference to the drawings, wherein Fig. 1 is a block flow diagram of the process; Fig. 2 is a detailed flow diagram of the process wherein a twin wire forming means is employed; Fig. 3 is a diagrammatic illustration of a single wire forming means to which the process of Fig. 2 may be applied; and Fig. 4 is a line graph illustrating qualitatively the relationships between residence time of fibers in an aqueous dispersion, the character of the aqueous phase of the dispersion, the effect of agitation and the caliper of the finished web.

Conventional fibers may include synthetic fibers such as polyester, polypropylene, polyethylene, polyamide, and nylon fibers, as well as chemically modified cellulosic fibers such as rayon, cellulose acetate, and other cellulose ester fibers. These synthetic and modified natural fibers are now used commonly in the manufacture of fibrous webs, either alone or in combination with natural cellulosic fibers when specific attributes of the web are desired. For example, a blend of synthetic and natural cellulosic fibers is advantageous to obtain a multi-use, ultimately disposable, industrial wipe. The synthetic fibers provide absorbency. The conventional fibers incorporated into the webs of the present invention may be hydrophobic or hydrophilic, although for webs traditionally perceived as paper products, hydrophilic natural cellulose fibers are employed.

The treated fibers are non-fibrillated hydrophilic paper-making fibers which have been treated in a manner as to provide kinks, twists, curls, or other distortions, and may be derived from those above mentioned conventional fibers which are hydrophilic. Hence, the class of treated, i.e., anfractuous, fibers includes all of the natural cellulose fibers referred to above as well as chemically modified cellulosic ester fibers, which fibers are generally considered hydrophilic when the degree of substitution of hydroxyl groups present therein is less than about 1.0. The plurality of intorsions present among the treated fibers provides said fibers with three dimensional characteristics not present substantially in the first class of conventional (untreated) fibers which are structurally ribbon-like. When laid in a web, the conventional fibers tend to lie flat within the web along the x-y plane. Conversely, the treated fibers are randomly distributed three dimensionally within the web. That is, there is substantial penetration of the treated fibers into the plane of the web (the z plane).

The treated fibers are further characterized in that the degree of treatment is sufficient to create the kinks, curls and other intorsions, yet is not so severe that the fibers become permanently kinked. Thus, because the treated fibers are hydrophilic, they tend to return to their original shape in a relatively short time after they are slurried in an aqueous medium. The rate of relaxation of these relatively short-lived intorsions is relatively rapid during the first few minutes after they are wet with water, but is dependent on a number of factors including the severity of treatment during preparation, the consistency of the slurry, the presence or absence of agitation, the severity and nature of said mixing (if any), the temperature of the aqueous medium, the presence of wetting agents,

and the like. However, even under essentially ideal conditions of no agitation and ambient temperature, but at conventional process utilization consistency, i.e., consistencies less than about 10% by weight, the treated
5 fibers relax considerably after about 1 to about 10 minutes in a water environment. Conventional web manufacturing methods, which require pulping and storage operations that proceed over several hours, typically one to six hours with vigorous agitation, are thus not able to realize the
10 advantage of the intrinsic nature of the treated fibers utilizable in the present invention.

The preferred means for preparing the treated fibers is to defiberize dry laps made from treatable fibers in a hammer-
15 mill. By "dry" is meant that no free water is present in the fibers, although the laps, bales or the like will normally contain as much as about 15% equilibrium moisture by weight as a result of storage under atmospheric conditions.

20 The average residence time of the fibers in the hammermill is preferably less than about one second, thus providing a rapid method and means of preparation of the treated fibers. The moisture content of the fibers leaving the
25 hammermill is about 1 to 5% by weight, and is essentially a function of the equilibrium moisture content of the particular fiber at the mill temperature.

As an alternate to hammermilling, the treated fibers may be
30 produced by wet milling in a disk refiner. The preferred wet milling apparatus is a Chemifiner manufactured by Black Clawson Corporation. In the Chemifiner, fiber curling and kinking is accomplished by subjecting a nodular mat of pulp to gyratory motion under compression between a driven disk
35 and a hydraulically loaded eccentrically opposed "floating

disk" rotating in the same direction at nearly the same speed. The patterned faces of the disks provide tractive surfaces so that the pulp nodules are continuously re-oriented as they roll and traverse from the center inlet
5 port to the peripheral discharge zone. Pulp consistency is typically between 15 and 50% fiber by weight, preferably between 30 and 45% by weight. Maximum hydraulic loading pressure is about 50 psi, while the floating disk rotates at a speed of between 100 to 500 ft./min. An eccentricity
10 of 0.075 inch has been used to obtain suitably kinked fibers. Disk clearance is variable but generally should be less than 0.1 inch, preferably about 0.07 inch.

In a preferred embodiment of the process of the present
15 invention, the treated kinked fibers as well as untreated conventional fibers are dispersed within a foamed liquid media comprising water, air and surfactant, the resulting foam furnish being dispensed onto a moving foraminous
20 forming means to obtain a wet web of about 12% fiber by weight. Excess liquid draining through the foraminous forming means is collected and recycled in a closed loop system. The preferred foraminous forming surface is of the twin wire type, that is, two separate foraminous wires
25 converging to form a nip, the furnish being jetted into the nip from a forming header provided with an injection nozzle. The wet web is then dried conventionally, the ultimate web product having a moisture content of about 5%
30 water by weight. Standard processing treatments that may be performed on the web between forming and take-up on a parent roll include wet pressing, consolidation, embossing, and creping, each such operation being well known in the art of web manufacturing.

The web product comprises at least 10% by weight of the
35 treated fibers described previously, the remaining 90 to 0%

by weight of the web being the aforesaid untreated conventional fibers. Preferably, the weight ratios of treated to untreated fibers is in the range about 3:1 to 1:3.

5 Fig. 1 is illustrative of the process, illustrating the sequence of principal operating steps in block diagram format. Referring to Fig. 1, a pulp of untreated fibers, as hereinbefore defined, is first prepared in a manner conventional in the art. The pulp may be obtained directly
10 from existing mill operations, or may be prepared from laps, bales, or rolls of untreated fibers in a repulping operation. Typically, the pulp slush thus obtained has a consistency of between about 3.0 to about 6.0% untreated fiber by weight. Because a closed loop furnish system is
15 used, the consistency of the untreated fiber slush pulp must be high enough to ensure that a surplus of water will not develop within the loop. For this reason the pulp is pressed to a consistency of between about 8 to about 50% fiber by weight, preferably between 15 to 35%.

20 The high consistency slush pulp of untreated fibers is then dispersed within the foamed media along with treated fibers. In the preferred embodiment a portion of the foamed liquid recovered from the forming apparatus is used to
25 provide a furnish predilution consistency of between about 1.5 to about 4.0% fiber (treated and untreated) by weight, the remaining portion of foamed liquid subsequently being used to further dilute the furnish to a final (headbox) consistency of between about 0.3 to about 1.2% by weight.
30 The wet web is then laid as mentioned above. Any deficit in water and/or surfactant circulation in the closed loop system is made up continuously by addition to the foamed liquid collection apparatus.

35 Reference is now made to Fig. 2, a detailed flow diagram of

the preferred embodiment of the process. The apparatus of the process as well as the process start-up procedure developed to initially generate the foam medium is described in commonly assigned pending U.S. Patent Application S.N. 179,229 entitled "Apparatus and Method for the Manufacture of a Non-Woven Fibrous Web", filed August 8, 1980 by James Cheshire et al, which application is incorporated herein by reference.

10 In the steady state operation of the process of Fig. 2, the foamed furnish of about 0.3 to about 1.2 weight % consistency is jetted into a nip 14 formed between converging endless foraminous wires 11, 12 from headbox 21. Wire 11 is supported by rolls in conventional manner, rolls 16, 17, 15 18 being shown. Similarly, wire 12 is supported by rolls, only roll 19 being shown in Fig. 2. The support rolls are positioned such that the wires 11, 12 are caused to wrap around a portion of a smooth impervious cylindrical forming roll 20. In Fig. 2, the wire 12 is in direct contact with 20 roll 20 (i.e., the inner wire), while the wire 11 (the outer wire) is superposed on wire 12. Rolls 16, 17, 19 and 20 are situated such that the nip 14 is formed tangential to roll 20, the nozzle 22 of headbox 21 jetting the furnish 23 into 25 said nip, thereby distributing the fibers contained herein randomly between the wires 11, 12. The larger portion of the foamed liquid is pressed or squeezed from between the wires as they travel about the impervious roll 20, passes through the outer foraminous wire 11, and into a saveall 26 proximate to said wire 11. A minor portion of the liquid, 30 essentially water with a low concentration of surfactant, is retained within the distributed fibers. As the wires 11, 12 diverge at roll 18, a wet web W is caused to remain on support wire 12 by application of vacuum in vacuum box 25, although it is also possible for web W to follow the path 35 of wire 11 if desired. Web W contains between about 85 to

about 93% water by weight, the remainder being the fibers and small amounts of surfactant. Some liquid is withdrawn by the vacuum means (not shown), and may be returned to the system. The wet web W is processed subsequently in a manner
5 conventional to the art, ultimately being dried to less than about 3% to about 10% moisture by weight.

Foamed liquid collected in the saveall 26 is withdrawn therefrom via line 27 and is directed to a silo 31, the
10 inlet thereto being in the lower region of silo 31 and below the liquid level therein. Make-up water is added to the silo 31 through line 35, while make-up surfactant solution is added from surfactant mix tank 36 via pump 37 through line 38. An agitator 32 is provided in silo 31 to mix the
15 contents thereof.

A pulp of untreated fiber is prepared conventionally in pulp tank 40, the consistency thereof being about 1.0 to 4.0% fiber by weight. A well mixed dispersion of the fiber
20 is obtained by high shear agitator means 41. The pulp may be prepared as part of an integrated mill operation, or may be made by repulping laps, bales or rolls of dried untreated fibers. In the latter case of a repulping operation, a uniform fiber slurry is obtained by vigorous mixing for at
25 least 15 minutes, preferably 30 minutes or longer. Typically, the pulping operation is performed batchwise, the slush pulp being subsequently stored in a machine chest 42 having storage capacity of three to six hours or more to provide an always available supply of pulp. The slush pulp
30 is withdrawn from tank 40 (or from the machine chest, if used) by pump 43 and is directed to a stock press 44. Leaving the stock press 44 through line 45, the pulp has a consistency sufficient to require the addition of make-up water and surfactant solution to the closed loop foam
35 system via lines 35 and 38 respectively. A suitable stock

press is available from Arus-Andritz. The consistency of the pulp in line 45 can be calculated easily by material balance. In general, however, the consistency is between 8 and 50 weight %, preferably between 15 and 35 weight %.

5 Water removed from press 44 is recycled to the tank 40 through line 46, while the high consistency pulp of line 45 is introduced to the mix tank 61 well below the liquid level therein. It is, of course, apparent that where webs of 100% treated fiber are to be made, that the above described

10 pulping or repulping procedures are not required.

Concurrently with the preparation of untreated fibers, treated fibers are prepared for introduction into mix tank 61. In the preferred embodiment, untreated pulp laps or

15 bales 57 are defiberized in a hammermill 52 in a manner so as not to substantially create fibrillation of the fibers as mentioned above. Individual fibers 53, now having the anfractuous characteristics hereinbefore described, are transported pneumatically in duct 55 via blower 54 to mix

20 tank 61, wherein they are added above the liquid level therein. Transport air is withdrawn from tank 61 through vent 63.

Foamed liquid from the silo 31 is transferred by pump 65

25 through line 66 to tank 61. Pump 65 is of the twin screw type capable of transferring low density liquids such as the foamed liquid. The volume of foamed liquid thus transferred is that amount necessary to obtain a mix tank consistency of between about 0.3 to about 4.0% fiber by

30 weight, preferably between 1.5 to 4.0%. An agitator 68 provides the requisite energy to disperse the fibers rapidly, but gently such that wetting of the treated fibers is minimized as is hereinafter described. The foamed furnish of treated and untreated fibers leaves the mix tank 61 by

35 line 69, a twin screw pump 71 providing the motive energy

therefor. The discharge from pump 71, line 72, is directed to a deflaker 73, which is a very low residence time, high shear device capable of breaking apart bundle or clumps of fibers that may exist, and which would ultimately compromise the formation quality of the wet web W. The deflaker 73 comprises a plurality of disks with interlocking protruding fingers, through which the fiber bundles pass. The residence time in the deflaker is quite low, being on the order of a few seconds at commercial flow rates. A suitable deflaker is available from Impco-Escherwyss.

In the preferred embodiment, that is, where the mix tank consistency is between 1.5 to 4.0% fiber by weight, additional foamed liquid is pumped from the silo 31 by twin screw pump 75 through line 76, and is combined with the deflaker discharge, line 74, the combined streams 78 being introduced to headbox 21. Screen 79 is provided in line 78 to remove debris therefrom, which debris may cause mechanical problems in downstream equipment as well as poor product webs. The flow rate in line 76 is such that the furnish of line 74 is further diluted to a final (headbox) consistency of between about 0.3 to about 1.2% by weight. Where the mix tank consistency is less than 1.2% fiber by weight, further dilution is not required.

It has been found that utilization of the process flow scheme just described, within operating constraints outlined below, does not afford sufficient opportunity for relaxation of the treated fibers which, if laid conventionally, would lose their short-lived distortions and their high bulking attributes. The webs obtained by the present process have superior formation quality as compared with webs not containing treated fibers, and prepared by the conventional wet laid process.

The foamed liquid used herein comprises air, water and surfactant. The properties of the foam are dependent on air content, ranging between 55 and 75% by volume; the bubble size, ranging between 20 and 200 microns in diameter, and the surfactant selection. The surfactant may be anionic, non-ionic, cationic or amphoteric, provided it has the ability to generate a foamed dispersion. A preferred ionic surfactant is an alpha olefin sulfonate marketed under the trade name "Ultrawet A-OK", by Arco Chemical Company, Philadelphia while a preferred non-ionic surfactant is a peg-6 lauramide, marketed under the trade name "Mazamide L-5AC" by Mazer Chemical Co., Chicago. The concentration of surfactant in the silo 31 is about 150 to 450 ppm (parts per million) by weight, and varies within the process depending upon the material balance. About 4 to 22 kilograms or surfactant per kilogram of dry fiber in web W is lost from the system and is made up through line 38. Bubble size and air content vary throughout the closed loop, and are self-regulating.

As the liquid passes through wire 11 into saveall 26, air within the perforations of the wire 11 and ambient air is entrained in the liquid as it is drawn into the saveall 26, thereby increasing the air content of the foam to between about 70 to 75% by volume. The foam is transferred to silo 31, the larger sized, more unstable bubbles stratifying in the upper region of the silo, forming a frothy layer. Because these large bubbles are low in liquid content, they tend to collapse, the liquid therein returning to the lower silo region.

Liquid residence time in the silo is about 20 seconds, which time is sufficient to introduce make-up water and make-up surfactant solution. The removal of excess air and the introduction of surfactant, along with agitation by agita-

tion means 32 provides a foam of about 55 to about 70 percent air by volume, preferably between 60 and 70 percent, with bubbles ranging in size between about 20 to about 200 microns, but typically averaging about 50 to 150 microns. The surface tension of the foam is within the range of from about 20 to about 70 dynes/cm. The foam in silo 31 has a relatively low viscosity as a consequence of the relatively large bubble size, the viscosity being in the range of about 10 cps (centipoises) to about 200 cps as measured by a Brookfield LVS viscometer. The average viscosity of the foam at room temperature as measured by a Ford No. 4 Cup is within the range of 9.3 to 11.3 seconds.

In mix tank 61, the foam has substantially the same air content and bubble size quality as in silo 31, the amount of water added with the untreated fibers through line 45 being minor in comparison to the water in recycled foam added through line 66. At the viscosity values of the foam in mix tank 61, the untreated fibers, and more importantly, the treated fibers from duct 55 can be dispersed rapidly and at low shear. Hence, residence time is quite low in mix tank 61, typically below 5 minutes, preferably below 3 minutes, for greater retention of the high bulk properties of the treated fibers.

The agitator means 68 provides good dispersion of the fibers. For best dispersion, a mix tank consistency of between 1.5 to 3.5% by weight is preferred. Low shear propeller type agitators are preferred. Variable speed agitation drives are desirable to allow adjustment to minimum mixing energy required for blending the fiber dispersion and operate at energy levels such that turbulence is minimized, yet is sufficient to adequately disperse the fibers.

The ratio of the foamed liquid flow rate of line 76 to the flow in line 66 is from about 10:1 to about 6:1 in the preferred process embodiment. Hence, when foamed liquid from silo 31 is combined with the furnish from line 74, the
5 foamed liquid within line 78 will have substantially the same quality as that in silo 31.

The final (headbox) furnish in line 78, whether or not subject to dilution from line 76, is at a consistency of
10 about between 0.3 to about 1.2% fiber by weight, and has a viscosity of about 10 cps to about 35 cps on a fiber free basis.

Fig. 3 illustrates an alternate arrangement of a forming
15 apparatus 100 comprising a single wire adapted for use in the present invention. Apparatus 100 is of the suction breast roll type wherein a single forming wire 102 partially encircles a breast roll 109, said wire 102 further being suggested and driven by additional guide rolls (not
20 shown) of known construction. A headbox 104 feeds the foamed fiber dispersion hereinbefore described through conduit 103, and is positioned and operative to discharge same through the elongate nozzle 105. Nozzle 105 is fabricated with an upper arcuate wall 106 and an apron lip
25 107 such that the foam dispensed therefrom is directed onto wire 102. A saveall 120 is positioned with its opening just below the region of the forming wire 102 tangent to and downstream of roll 109.

30 Breast roll 109 is a hollow cylinder provided with a large number of perforations defined by large diameter outer bores 110 and lesser diameter inner bores 111, the bores being coaxial and whose axes extend radially of the roll 109. A fine mesh screen 112 extends about and closely
35 overlies the perforate outer surface of the roll 109.

Inside the roll 109 are a pair of low pressure zones 113, 114 defined by suitable baffles and vacuum producing means of known construction, said baffles being positioned such that the portion of the roll 109 underlying arcuate wall 106
5 of nozzle 105 is subject to the vacuum in low pressure zone 114. A foil 121 on saveall 120 is positioned in a manner such that removal of liquid from the underside of wire 102 is ensured as it carries the wet web away from the breast roll for subsequent treatment.

10

In operation, foamed liquid-fiber dispersion is dispensed onto the wire 102, liquid being withdrawn by vacuum zone 113 through both wire and screen, said liquid being stored in bores 110. As wall 109 rotates, wire 102 parts from the
15 surface of the roll 109 the liquid in bores 110 being centrifuged outwardly through the screen 112 into saveall 120. The liquid from the saveall is returned to the silo through line 122.

20 By including the treated fibers within the webs, the bulk, formation, liquid holding capacity, and softness properties of the web are enhanced. Bulk as used herein is defined as the caliper of an eight ply web in mils divided by the web basis weight in grams per square meter increased
25 eightfold, the caliper being measured at a constant load of 26.6 g/cm² using a 5 cm anvil, unless noted otherwise.

The improvement in bulk realized by the incorporation of the treated fibers appears to be dependent on a variety of
30 factors. As between the wet and dry milling procedures previously described, dry milling, as in a hammermill, provides about 15 to 35% greater bulk, than wet milling, other parameters being constant, and is preferred.

35 It has been found that a 0.3 to 4.0% consistency foam

furnish can be prepared in mix tank 61 using conventional agitation means, provided that the duration of fibers in the mix tank 61 is limited, on average, to less than about 5 minutes for wet milled fibers. As indicated qualitatively in FIG. 4, the bulk of the final web products is maximized by the lowest residence time and the least severe agitation required to produce substantial dispersion of the treated fibers in the furnish. Preferably, residence time is about 5 and about 3 minutes for dry and wet milled fibers, respectively. Residence time in the furnish transport line 78 is negligible because the duration is short as compared to mix tank residence time, and because axial mixing is low. Deflaker 73 residence time is also too low to provide substantial relaxation of treated fiber characteristics.

As would be expected, compaction of the web in any operation wherein the web is pressed, including for example the compaction provided by drying on a Yankee roll, reduces final web product bulk. However, a substantial beneficial effect on bulk due to the use of the treated fibers remains. In general, the bulk of the webs of the present invention which are wet pressed subsequent to forming in order to reduce the drying load are approximately equal to the bulk of conventional wet laid webs which have not been wet pressed. The bulk of such products is significantly greater than like products of conventional untreated fibers.

It has also been found, however, that bulk lost during compaction is recovered by creping the web, preferably just as the web comes off the Yankee. Apparently, the creping operation, which provides softness to towel and tissue products by breaking excessive hydrogen bonds extant in conventional paper products, releases treated fibers com-

pressed during compaction and locked in place during drying, and allows these fibers to substantially "spring back" to their contorted shape. It should be understood that the treated fibers as defined herein do not lose their desirable bulking properties in the dry state.

Example 1

Although comparisons are at best only guides to the bulk enhancement achieved by the process, Table 1 below illustrates typical results obtained in the preparation of handsheets.

Water formed handsheets comprising 100% untreated fibers were formed as follows: The pulp was placed in a British Disintegrator at a consistency of 12.5 g/l and mixed for 5 minutes. The slurry was then diluted to about 0.3% consistency, and the handsheet formed in a Williams sheet mold. The sheet was removed from the mold using a fabric and vacuum, and then transferred to a blotter. For compacted handsheets, the blotter was placed on a metal plate with the handsheet face up. A wet blotter was placed atop the handsheet, and a second metal plate placed thereon. The metal plates were then passed through an unloaded Appleton Handsheet Calender at low speed. Both non-compacted and compacted handsheets (and first blotter) were dried on a hot plate. Basis weight of sheets thus formed were 24.13 g/m².

The foam media handsheets were made by preparing a suitable foam in a Denver cell using water and Arco "Ultrawet A-OK"TM surfactant. The foam was transferred to a high speed mixer operating at 15,000 RPM along with sufficient fiber to form the sheet. Mixing was performed for 30 seconds. The foam furnish was then poured into a Williams sheet mold. Sub-

sequent steps were the same as the water formed handsheets.

Table 1

Fiber Type	Amount (%)	Forming Media	Bulk mil/g/m ²	Non-
			Compacted	Compacted
Untreated	100	Water	0.207	0.321
Untreated	100	Foam	0.240	0.372
Wet Milled	100	Foam	0.280	1.468
Dry Milled	100	Foam	0.326	0.508

As indicated in Table 1, the use of foamed liquid increased the bulk of the untreated webs from 0.207 to 0.240 mil/g/m² in the case of compacted sheets, and from 0.321 to 0.372 mils/g/m² for non-compacted sheets, the improvements being 15.7 and 15.8% respectively. Further increases in bulk were obtained in webs made of treated fiber, particularly from dry milled fibers. Compacted webs of wet milled fibers had a bulk improvement as compared with foam formed untreated fibers of 17.2%, while dry milled compacted webs had an improvement of 35.9%. Similar results were observed for non-compacted webs made from the treated fibers.

As the interstitial voids in a web are increased, the absorbency rate of the product web increases, apparently due to decreased resistance to fluid flow. Oil holding capacity increases 50 to 500 percent (based on weight of the oil absorbed per unit weight of dry fiber) as the interstitial voids are increased by the substitution of treated fibers for conventional fibers in the finished web. Water holding capacity also increases as a result of the greater porosity of the webs as determined by the Proposed ASTM Method, submitted to ASTM Committee D-6 entitled "Water Holding Capacity of Bibulous Fibrous Products".

By the process of this invention, the formation of the product web is greatly improved as compared with webs produced by conventional processes that is, the uniformity of the distribution of individual fibers comprising the web is enhanced as observed by absence of flocs in the web upon visual inspection. A better formed web characteristically improves subsequent web processing operations inasmuch as the web is less likely to tear during drying, creping, embossing and the like on a high speed fourdrinier machine.

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10 Formation of the web may be measured in a Thwing formation tester under Method No. 525 of the Institute of Paper Chemistry. In this procedure, the degree of uniformity of the web is ascertained by the degree of uniformity of light transmission through an area of the web. The Thwing Index

15 (TI) is the ratio of localized variations in transparency to average transparency. Low basis weight products obtained by conventional web processing methods, e.g., tissue, towel, and napkin products having a basis weight between about 13 to 80 g/m², have a TI of between 5 and 15,

20 which values are, of course, dependent upon process conditions and operations. At slower wire speeds, TI values are higher, while at faster speeds, the formation is affected adversely. For webs prepared on a high speed pilot machine in accordance with the process of the present

25 invention, wherein coarser treated fibers are incorporated, TI values were measured at between about 20 to 25, significantly higher than comparative wet laid webs. It is also expected that high bulk products having very high TI values can be made, and that these products can be made at

30 faster wire speeds than those used currently to make low bulk, high TI products.

The tensile strength of the product webs produced by the process of this invention are generally less than those

35 produced by conventional wet pulp papermaking processes.

In our process, tensile strength is reduced as the relative proportions of treated fibers to untreated fibers in the product web is increased. The reduction in tensile strength occurs because the treated fibers in the web are less capable of hydrogen bonding than are regular fibers due to reduced active surface area available for bonding. In webs containing 50% by weight or less of the treated fibers, sufficient hydrogen bonding is obtained to provide a product web of adequate strength. Minimum geometric mean tensile strength for products of the present invention would be about 400 g/7.62 cm strip, although preferably minimum geometric mean tensile would be between 400 to about 700 g/7.62 cm strip sufficient to meet acceptable standards applicable to the particular end use. For certain products, for example, low basis weight tissue and towel products, high tensile due to hydrogen bonding is disadvantageous; webs produced by conventional processes are often creped to eliminate excessive hydrogen bonding and to provide softness. With webs containing more than 50% by weight of treated fibers, a bonding agent may be used to provide added tensile strength as required by the ultimate end use. Suitable bonding agents include cationic starch; polyvinyl alcohol; pearl starch; natural gums (tragacanth, karaya, guar); natural and synthetic latex, including polyacrylates, e.g. polyethylacrylate, and copolymers; vinyl acetate-acrylic acid; copolymers; polyvinylacetates; polyvinyl chlorides; ethylene-vinyl acetates; styrene-butadiene carboxylates; polyacrylonitriles; and thermosetting cationic resins, eg. urea formaldehyde resins, melamine formaldehyde resins, glyoxal-acrylamide resins and polyamide-epichlorhydrin resins as disclosed in U.S. 3,819,470. Bonding materials are desirable where the conventional fibers used in the web are not self-bonding, as in certain synthetic and chemically modified cellulosic fibers.

Example 2

A series of three runs were made on a high speed twin wire paper machine at about 300 m/min. One run was a control
5 using repulped Ontario Softwood Kraft (OSWK) fibers that had been refined to 400 CSF. Two subsequent runs were made using 100% dry milled fibers comprising a mixture of softwood spruce fibers from Stora-Koppersburg and Rayfloc
10 XJ southern softwood fibers from Ranier Corporation (hereinafter Stora-XJ fibers) said fiber mixture having been treated previously with a debonding agent. In each run the Stora-XJ fibers were added directly to the mix tank, the furnish therein being at 1.8% consistency. Headbox consistency was adjusted to 0.45% by dilution with foamed
15 liquid from the silo. Arco "Ultrawet A-OK" surfactant was used to generate the foam in all runs. The amounts of fiber used in each run was such as to obtain product webs of comparable basis weights. The webs were wet pressed and subsequently dried and creped on a Yankee dryer, but were
20 not calendered.

Web properties for each run are tabulated below:

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Table 2

Run No.	1	2	3	
5	Fiber Type	100% OSWK	100% Stora-XJ	
	Basis Weight, g/m ²	57.9	58.1	62.3
	8-Ply Caliper, mils	77.5	157.3	147.3
	Bulk, mil/g/m ²	0.167	0.338	0.296
10	Percentage Solids on Wire:			
	Before Vacuum	8.8	20.2	n/a
	After Vacuum	15.7	31.9	n/a
	% Solids on Felt	19.8	23.3	n/a
	% Solids at Yankee	43.7	57.9	n/a
15	Instron Dry Tensile,			
	g/7.62 cm			
	MD	9840	146	385
	CD	3148	56	221
20	MD/CD	3.1	2.6	1.7
	Instron Elongation, percent:			
	MD	31.2	17.7	25.9
	CD	3.6	8.0	5.2
25	Oil Holding Capacity Ratio			
	g oil/g fiber	3.13	9.24	7.23

Although substantial improvement in bulk was realized for both webs made of Stora-XJ fibers, these webs had low tensile properties. Low tensiles were expected inasmuch as dry treated fibers have low fiber bonding tendency. Further, the presence of debonder lowered bonding even more. The high tensiles of the OSWK web is attributable to the refining of OSWK fibers prior to their use. A comparison of the percent solids data for runs 1 and 2 indicates that water drainage was superior from the pores, high bulk web comprising the treated fibers. Similarly, the high bulk of the webs of runs 2 and 3 provided significantly higher oil holding capacity for these webs.

Example 3

Test runs were made on a high speed twin wire paper machine operating at 457 m/min. In each run a pulp of 3.5% consistency was made comprising 50% OSWK and 50% OHWK untreated fibers. Treated fibers were not included in these runs, which are controls. After pulping the slush pulp was pressed to 28% consistency and added to the mix tank, and a foam furnish of about 0.6% fiber by weight delivered to the headbox. Air content ranged between 58 to 70%. The webs were wet pressed, dried and creped. In Runs 5 and 6 the webs were calendered.

Properties of these webs are tabulated below:

Table 3

<u>Run No.</u>		<u>4</u>	<u>5</u>
5	Fiber Type	50% OSWK/50% OHWK	
	Calender Roll Pressure,		
	kg/m ²	3515	3023
	Basis Weight	14.2	17.6
	8 Ply Caliper, Mils	45.9	47.1
10	Bulk, mil/g/m ²	0.248	0.206
	Instron Dry Tensile,		
	g/7.62 cm		
	MD	429	732
15	CD	275	542
	MD/CD	1.6	1.35
	Instron Elongation, %:		
	MD	26.4	24.3
20	CO	4.8	3.7

EXAMPLE 4

25 A series of eight runs were made on the high speed twin wire
 machine at 457 m/min. The webs were made with a blend of
 OSWK and Stora-XJ fibers in accordance with the present
 process except that the treated fibers were admixed in the
 pulp tank for about five minutes rather than direct dis-
 30 persion in the mix tank. One set of runs (Group A)
 contained a 50-50 mixture of the aforesaid fibers; the runs
 of Group B comprised 72% treated fibers and 28% untreated
 fibers. Webs in both sets of runs were formed at a
 consistency of about 0.60% fiber by weight, and the air
 content of the foam was about 65-66% at the headbox. The
 35 wet webs were pressed, transferred to a felt, and dried and

creped. Each web was calendered at roll pressures of between 140 and 560 g/cm², as noted. It should be understood that the five minute mixing period for those runs involving pulp tank addition of the treated fibers is considerably less than the pulp preparation time in commercial facilities. Even so this unusually short period of treated fiber high shear mixing produced a noticeable decrease in bulk. For example, Run 6 provided a web of 0.265 mil/g/m² as compared to bulks of 0.284 and 0.281 for the webs of Runs 15 and 16, respectively, in Example 5.

The web properties are tabulated below:

Table 4

Run No.	GROUP A		
	6	7	8
Fiber Type	50% OSWK/50% STORA-XJ		
Calender Pressure, g/cm ²	140	350	560
Basis Weight, g/m ²	29.30	28.48	28.64
8 Ply Caliper, Mils	62.2	58.2	51.7
Bulk, Mil g/m ²	0.265	0.255	0.226
Instron Dry Tensile, g/7.62cm			
MD	1485	1334	1403
CD	965	850	881
Instron Elongation, %			
MD	40.7	39.2	36.8
CD	4.9	4.5	4.6

GROUP B

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EXAMPLE 5

5 A series of four runs were made on the high speed twin wire
machine at 457/m/min. The webs were made with a blend of
OSWK nd Stora-XJ dry milled fibers in accordance with the
process of this invention. The milled fibers were added to
the mix tank. The four runs used a 50/50 blend of said
fibers, and the webs were formed at a consistency of 0.6
percent, the foam having an air content of 67% at the
10 headbox. The wet webs were pressed, transferred to a felt,
dried and creped.

The webs were calendered as noted below and had the proper-
ties tabulated:

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Table 5

Run No.	14	15	16	17
5	50% OSWK/50% Stora-XJ			
	Fiber Type			
	Calendering Roll			
	Pressure, g/cm ²			
	0	140	140	350
10	Basis Weight, g/m ²			
	31.7	30	30.8	29.8
	8-Ply Caliper, Mils			
	87.8	65.9	69.1	62.2
	Bulk, Mil/g/m ²			
	0.346	0.275	0.280	0.266
15	Instron Dry Tensile,			
	g/7.62 cm			
	MD	628	742	748
	CD	475	602	539
	MD/CD	1.3	1.2	1.4
20	Instron Elongation, %			
	MD	37.8	36.2	39.5
	CD	5.9	5.0	6.1

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EXAMPLE 6

Eleven runs were made on the high speed machine operating at 305 m/min. using a foamed liquid furnish. The treated
 5 fibers used therein were introduced at the mix tank. Runs 18 to 20 were controls using 100% untreated OSWK fibers refined to 480 CSF. Runs 21 to 24 contained a mixture of 50 percent untreated OSWK fibers and 50 percent dry milled
 10 Stora-XJ fibers as previously described, while runs 27 to 30 contained 20 percent untreated and 80 percent treated fibers.

Table 6

15	Run No.	18	19	20
	Fiber Type	100% OSWK		
	Calendered	No	No	Yes
20	Basis Weight, g/m ²	24.2	44.6	23.3
	8-Ply Caliper, Mils	57.5	72.7	51.0
25	Bulk, Mils/g/m ²	0.297	0.204	0.274
	Dry Tensile, g/7.62 cm			
	MD	1172	4148	999
30	CD	619	2133	565
	Elongation, %			
	MD	35.7	36.5	32.5
	CD	4.6	3.1	4.7
35				

Table 6 (continued)

Run No.		21	22	23	24
5	Fiber Type	50% OSWK 50% STORA-XJ			
	Calendered	No	No	Yes	Yes
	Basis Weight, g/m ²	21	24.9	23.6	24.1
10	8-Ply Caliper, Mils.	66.4	72.8	69.0	70.9
	Bulk, Mils/g/m ²	0.395	0.365	0.365	0.368
15	Dry Tensile, g/7.62 cm				
	MD	288	354	470	249
	CD	152	176	212	128
20	Elongation, %				
	MD	27.2	27.3	32.3	26.8
	CD	7.9	8.1	7.1	8.8

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Table 6 (continued)

Run No.		25	26	27	28
5	Fiber Type	20% OSWK 80% STORA-XJ			
	Calendered	No			
	Basis Weight, g/m ²	29.8	32.4	41.3	44.8
10	8-Ply Caliper, Mils	104.7	112.4	110.6	112.0
	Bulk, Mils/g/m ²	0.439	0.434	0.335	0.312
15	Dry Tensile,				
	g/7.62 cm				
	MD	137	149	471	417
	CD	59	66	221	226
20	Elongation, %				
	MD	23.0	21.9	25.5	23.6
	CD	10.9	9.4	5.2	5.6

25 The preceding disclosure is to be considered exemplary of the invention disclosed therein, the scope of said invention being defined by the claims appended below.

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Claims:

1. A process for the production of a fibrous web which comprises:

- 5
- a) forming treated hydrophilic papermaking fibers characterized by induced twists, kinks and curls and having the ability to retain their induced characteristic shapes for only a relatively short period of time when wet with water by
- 10
- subjecting hydrophilic papermaking fibers to mechanical deformation without substantial fibrillation or breakage of the fibers;
- b) forming a dispersion comprising said treated fibers in an aqueous medium capable of supporting and transporting said fibers, and
- 15
- c) forming a dewatered fibrous web from said dispersion within a period of time such that said treated fibers retain at least part of their induced characteristics in the web.
- 20

2. A process according to Claim 1 wherein said dispersion is formed with low shear agitation.

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3. A process according to Claim 1 wherein said dispersion has a consistency of from about 0.3 to about 1.2 percent fiber by weight.

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4. A process according to Claim 1 wherein said dispersion comprises a mixture of said treated fibers and conventional papermaking fibers and wherein said treated fibers comprise at least 10 percent by weight of all fibers present in said dispersion.

5. The process of Claim 1 wherein the papermaking fibers are natural cellulosic fibers.

5 6. The process of Claim 1 wherein the treated hydrophilic papermaking fibers comprise cellulose ester fibers having a degree of substitution of hydroxyl groups therein of less than 1.0.

10 7. The process of Claim 1 wherein said treated fibers are produced by hammermilling dry natural cellulosic papermaking fibers.

15 8. The process of Claim 2 wherein said treated fibers are produced by wet refining natural cellulosic papermaking fibers.

20 9. The process of Claim 7 wherein the moisture content of the treated fibers leaving the hammermill is preferably between 0.5 and 3.0% by weight.

10. The process of Claim 1 wherein the foamed dispersion contains a surface active agent to promote foam formation and enhance foam stability.

25 11. The process of Claim 1 wherein said period of time is not greater than 5 minutes.

30 12. The process of Claim 1 wherein said aqueous medium is a foamed aqueous liquid.

35 13. The process of Claim 12 wherein the foamed aqueous liquid contains from about 55 to about 75% air by volume, the air being present as dispersed bubbles in the size range of from about 20 to about 200 microns.

14. The process of Claim 4 further comprising the steps of dispersing the conventional papermaking fibers and treated papermaking fibers in foamed aqueous liquid to form a dispersion containing from 1.5 to 4 percent fibers by weight, and adding a further amount of foamed aqueous liquid as diluent to produce a dispersion containing 0.3 to 1.2 percent fiber by weight.

15. The process of Claim 13 wherein the consistency of the first dispersion before addition of diluent is from about 1.5 to about 3.5 percent fiber by weight.

16. The process of Claim 4 wherein the treated fibers comprise from about 25 to about 75 percent by weight of all fibers present in the dispersion.

17. The process of Claim 12 wherein the residence time of the treated fibers in the aqueous dispersion is not more than about 3 minutes.

18. The process of Claim 14 wherein the web is formed on a foraminous support means and foamed aqueous medium passing through the support means is collected and recycled as diluent.

FIG.1

FIG.1

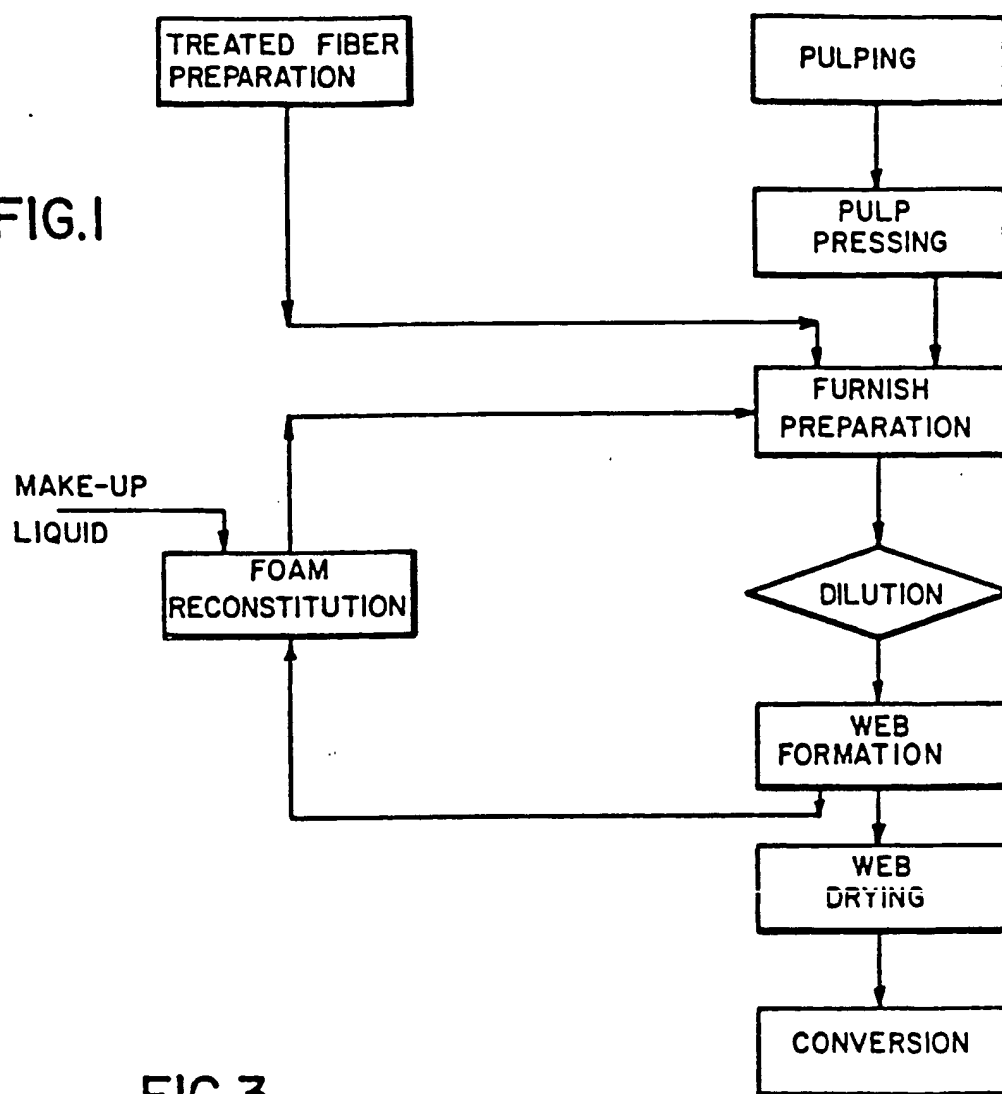


FIG.3

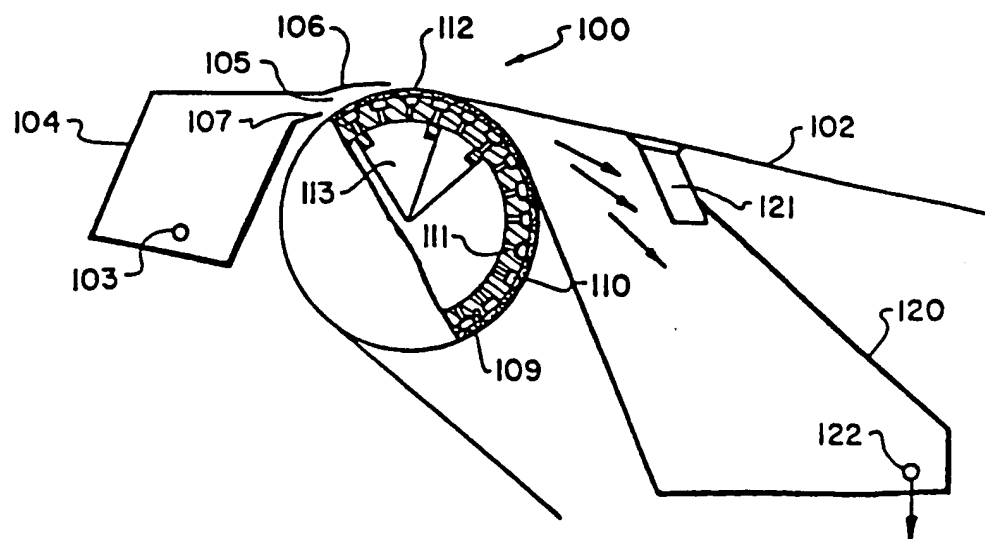


FIG. 2

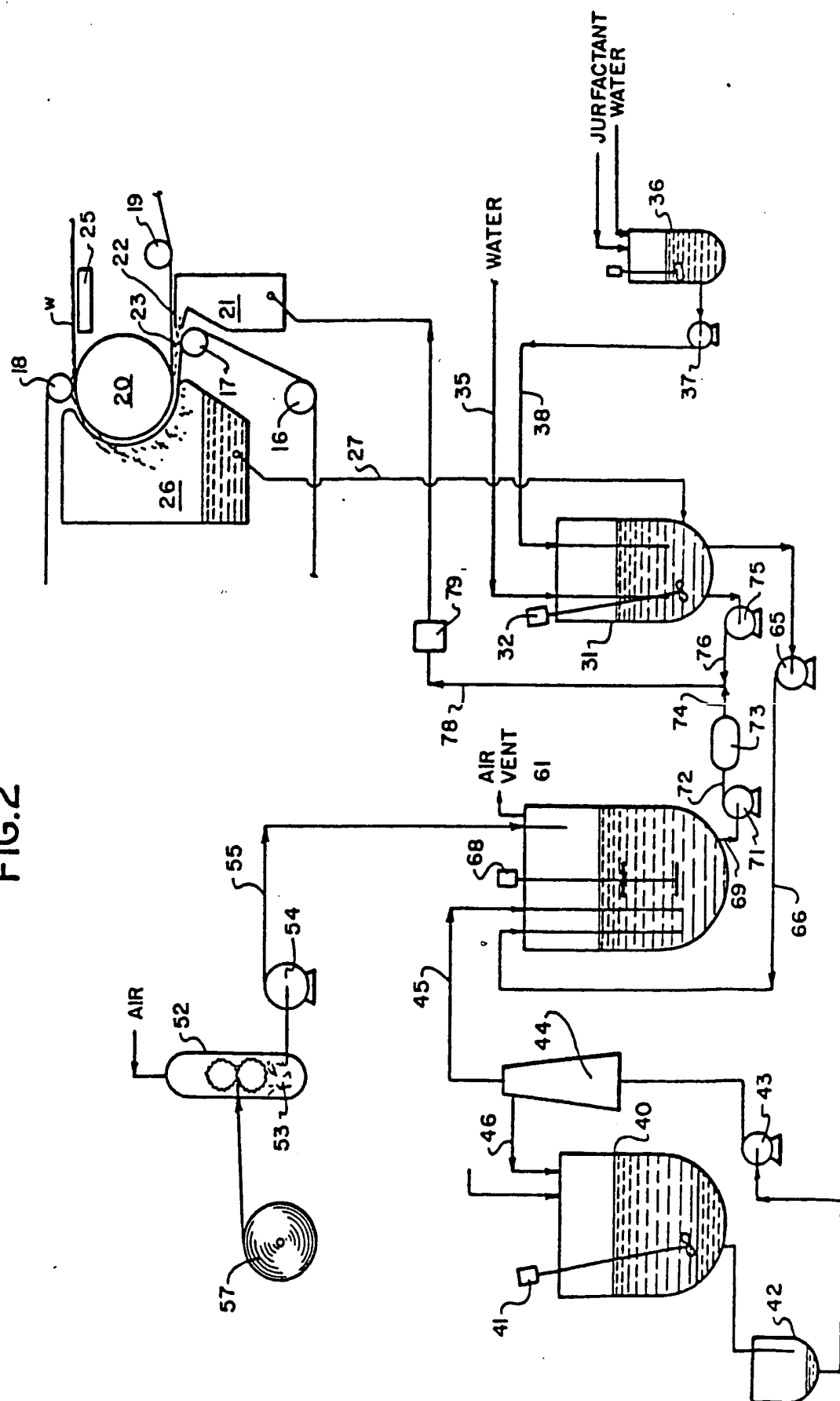


FIG. 4

